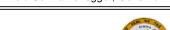
### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-020619 Address: 333 Burma Road **Date Inspected:** 13-Feb-2011

City: Oakland, CA 94607

OSM Arrival Time: 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** See below **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS: Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** OBG

**Summary of Items Observed:** 

CWI Inspectors: Mr. Sha Zhi and Mr. Guo Xing Hui

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair to make a weld repair of ultrasonic rejections to OBG segment 14E weld SEG3019D-1-323. ZPMC QC informed this QA Inspector that critical weld repair document B-CWR-2678 documents this weld repair. This QA Inspector measured a welding current of approximately 240 amps and Mr. Yang Yunfeng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Chen Ren Zhi, stencil 058087 used shielded metal arc welding procedure WPS-345-SMAW-2G(2F)-FCM-Repair to make a weld repair of ultrasonic rejections to OBG segment 14E weld SEG3019D-1-323. ZPMC QC informed this QA Inspector that critical weld repair document B-CWR-2678 documents this weld repair. This QA Inspector measured a welding current of approximately 240 amps and Mr. Chen Ren Zhi appeared to be certified to make this weld. Items observed on this date appeared to

## WELDING INSPECTION REPORT

(Continued Page 2 of 3)

generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Guo Taotao stencil 050969 used shielded metal arc welding procedure WPS-B-P-2212-TC-U4B-FCM to make OBG segment 14E weld DP3161-001-019. This QA Inspector observed Mr. Guo Taotao appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Ye Bing stencil 066733 used flux cored welding procedure specification WPS-B-T-2233-ESAB to perform OBG segment 14E welds SEG3019N-302, 303, 307 and 308. This QA Inspector observed Mr. Ye Bing appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Du Hengyou, stencil 067571 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 13AE welds SEG3007AB-030 and 032. This QA Inspector observed Mr. Qie Jian Zhou appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yuan Wensong, stencil 055491 used flux cored welding procedure WPS-B-T-2233-ESAB to make OBG segment 13AE weld SEG3007AX-033. This QA Inspector measured a welding current of approximately 260 amps, 27.0 volts and Mr. Yuan Wensong appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.



## **Summary of Conversations:**

See Above.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

# **WELDING INSPECTION REPORT** ( Continued Page 3 of 3 )

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer